

Work Order ID 63925



Page 1

Friday, November 19, 2010 8:44:48 AM

Item ID: D4272-013

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Basket Assembly, Lightweight Lid, LH

Start Date: 11/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 10-11-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4272	PA1

100 Pick Kit



Packaging

Packaging

110



HandFinish

Hand Finishing

Assemble as per dwg

0.00

0.00

10/11/19 SF

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

#1

- * Note: - Basket partially assembled.
- All key points have been assembled.
- No gas strut, i weekly ass'y required for testing by Engineering.
- See highlighted items that have not been assembled.

10-11-19 ①

1

10/11/03

Note #2:

- Basket was used for test internal.
- Basket was re-assembled; new hardware installed & shipping for flight testing
- lid closes not very well due to base twist from test.

P70

10/11/30

Work Order ID 63925

Page 2

Friday, November 19, 2010 8:44:48 AM

Item ID: D4272-013

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Basket Assembly, Lightweight Lid, LH



Start Date: 11/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

H. test. Rev. A.
10-11-23
MF 10-12-01

POSITIVE RECALLEFFECTIVE 10-11-09 AUTH YRELEASED DATE

Picklist Print

Page 1

Friday, November 19, 2010 8:44:47 AM

Work Order ID: 63925



Parent Item: D4272-013



Parent Item Name: Basket Assembly, Lightweight Lid, LH

Start Date: 11/19/2010

Required Date: 11/19/2010

Start Qty: 1.00 Required Qty: 1.00

Start Oty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.19 new issue DD verf:EC

Picklist Print

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Friday, November 19, 2010 8:44:47 AM

Work Order ID: 63925



Parent Item: D4272-013



Parent Item Name: Basket Assembly, Lightweight Lid, LH

Start Date: 11/19/2010

Required Date: 11/19/2010

Start Qty: 1.00

Required Qty: 1.00

X D2931



Bumper

Manufactured No 100 Each 768.0000 2



10/11/198

D3912-041



Eyebolt Receiver Assembly

D3915-041 063662 ENG Dant to step 155

Manufactured No 100 Each 0.0000 1



D61783 10/11/198

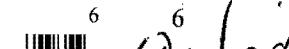
Light Lid Assemby, Long Basket

D3917-3



Washer

Manufactured No 100 Each 33.0000 6



10/11/198

X D3953-3



Gas Spring Stud, Lid

Manufactured No 100 Each 7.0000 2



10/11/198

Picklist Print

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Work Order ID: 63925



Parent Item: D4272-013



Parent Item Name: Basket Assembly, Lightweight Lid, LH

Start Date: 11/19/2010

Required Date: 11/19/2010

Start Qty: 1.00

Required Qty: 1.00

X-D3953-7



Spring Spacer

Manufactured	No	100	Each	8.0000	2	2	10/19/2010
--------------	----	-----	------	--------	---	---	------------

X-D3953-9



Gas Spring Washer

Manufactured	No	100	Each	8.0000	2	2	10/19/2010
--------------	----	-----	------	--------	---	---	------------

X-D3953-17



Gas Spring Spacer

Manufactured	No	100	Each	7.0000	2	2	10/19/2010
--------------	----	-----	------	--------	---	---	------------

X-D3953-19



Gas Spring Bracket

Manufactured	No	100	Each	10.0000	1	2	10/19/2010
--------------	----	-----	------	---------	---	---	------------

Location	Loc Qty	Loc Code
ST101	7	
57143	1	
59197	6	
ST	10	
59213	10	

Picklist Print

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Work Order ID: 63925



Parent Item: D4272-013



Parent Item Name: Basket Assembly, Lightweight Lid, LH

Start Date: 11/19/2010

Required Date: 11/19/2010

Start Qty: 1.00

Required Qty: 1.00

X D3933-21

Manufactured

No

100

Each

18.0000

1

1

10/11/1980

Gas Spring Bracket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ENG	5	
56407	5	
ST102	13	
57145	2	
59214	11	

Manufactured

No

100

Each

7.0000

1

1

10/11/1980

X D3969-3

Spring (Basket Lid)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	3	
58986	3	
ST272	4	
63657	4	

D4021-5



Blanking Plate

Manufactured

No

100

Each

4.0000

1

10/11/1980

✓ D4150-041



Attachment Arm Assembly

Manufactured

No

100

Each

5.0000

1

10/11/1980

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST123	5	
60782	1	
60896	4	

Picklist Print

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Work Order ID: 63925



Parent Item: D4272-013

Parent Item Name: Basket Assembly, Lightweight Lid, LH

PA1064214.

D4151-041



Basket Fwd Hardpoint Assembly, Lower

Manufactured No

100

Each

3.0000

1

Start Date: 11/19/2010

Required Qty: 1.00

Start Qty: 1.00

Required Qty: 1.00

10/11/1989

D4151-043



Basket Fwd Hardpoint Assembly, Upper

Manufactured No

PA1064215

Location
ST123
60897

Loc Qty

Loc Code

3

3

100

Each

5.0000

1

10/11/1989

D4273-041



Basket Base Assembly, LH

Manufactured No

363833 to step 120

Location
ST
60787
ST124
60898

Loc Qty

Loc Code

1

1

4

4

100

Each

0.0000

1

10/11/2010

D4282-1



Wedge

AN3-10A

Bolt

Manufactured No

10-18-01

Purchased No

100

Each

0.0000

1

10/11/1989

Location
ST351
115877
116075

Loc Qty

Loc Code

82

38

44

3

Picklist Print

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Work Order ID: 63925



Parent Item: D4272-013



Parent Item Name: Basket Assembly, Lightweight Lid, LH

Start Date: 11/19/2010

Required Date: 11/19/2010

Start Qty: 1.00

Required Qty: 1.00

AN3-11A



Purchased

No

100

Each

221.0000

2

2
10/11/1981

Bolt

Location	Loc Qty	Loc Code
ST351	221	
110865	121	
115457	100	

Purchased

No

100

Each

100.0000

4

4
10/11/1981

(X) AN3-14A



Bolt

Location	Loc Qty	Loc Code
ST351	100	
114941	50	
115108	50	

Purchased

No

100

Each

68.0000

2

2
10/11/1981

AN3-20A



Bolt

Location	Loc Qty	Loc Code
ST352	68	
105125	28	
115371	40	

Purchased

No

100

Each

31.0000

3

3
10/11/1981

AN4-12



Bolt

Location	Loc Qty	Loc Code
ST357	31	
114292	2	
114784	29	

Picklist Print

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Work Order ID: 63925



Parent Item: D4272-013



Parent Item Name: Basket Assembly, Lightweight Lid, LH

Start Date: 11/19/2010

Required Date: 11/19/2010

Start Qty: 1.00

Required Qty: 1.00

AN310-4



Purchased

No

100

Each

78.0000

3

3
10/11/98

NUT

Location	Loc Qty	Loc Code
ST324	78	
115107	24	
	8	
115936	6	
116075	20	
	50	

AN310C4



Purchased

No

100

Each

35.0000

3

3
10/11/98

Nut

Location	Loc Qty	Loc Code
ST349	35	
114306	35	

X MS20600-AD4W3



Purchased

No

100

Each

1,485.000

2

3
2
10/11/98

Cherry Rivets

Location	Loc Qty	Loc Code
ST321	1485	
107939	754	
111636	731	

MS21042L3



Purchased

No

100

Each

1,693.000

11

11
10/11/98

Nut

Location	Loc Qty	Loc Code
ST300	1693	
114784	697	

115835

996

11
10/11/98

Picklist Print

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Work Order ID: 63925



Parent Item: D4272-013



Parent Item Name: Basket Assembly, Lightweight Lid, LH

Start Date: 11/19/2010

Required Date: 11/19/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L4



Purchased

No

100

Each

5,709.000

6

6

10/19/10

Nut

Location	Loc Qty	Loc Code
ST300	5709	
113422	25	
114523	8	
115589	1076	6
115621	1100	
116188	3500	

MS21042L5



Purchased

No

100

Each

1,373.000

4

10/19/10

Nut

Location	Loc Qty	Loc Code
ST139	26	
114813	26	
ST300	1347	
115156	147	X
115594	500	
116104	200	
116105	500	

MS24665-151



Purchased

No

100

Each

607.0000

4

10/19/10

Cotter Pin

Location	Loc Qty	Loc Code
ST309	607	
17566	607	X

Picklist Print

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Friday, November 19, 2010 8:44:48 AM

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Parent Item: D4272-013



Parent Item Name: Basket Assembly, Lightweight Lid, LH

Start Date: 11/19/2010

Required Date: 11/19/2010

Start Qty: 1.00

Required Qty: 1.00

X MS24665-300

Purchased

No

100

Each

48.0000

2

2

10/11/10

Cotter Pin



NAS1149DN832J

Purchased

No

LocationLoc QtyLoc Code

ST309

48

105279

2

110123

46

WASHER



WASHER

NAS1149F0332P

Purchased

No

LocationLoc QtyLoc Code

ST298

461

115300

19

115470

5

115832

1

115996

236

116025

200

WASHER



Washer

NAS1149C0432R

Purchased

No

LocationLoc QtyLoc Code

ST275

495

18057

495

LocationLoc QtyLoc Code

ST297

382

114292

50

114742

332

Picklist Print

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Friday, November 19, 2010 8:44:48 AM

Work Order ID: 63925



Parent Item: D4272-013



Parent Item Name: Basket Assembly, Lightweight Lid, LH

Start Date: 11/19/2010

Required Date: 11/19/2010

Start Qty: 1.00

Required Qty: 1.00

~~NAS1149F0432P~~

Purchased No

100 Each 350.0000

18



18

11/19/10

Washer

Location	Loc Qty	Loc Code
ST275	350	
112940	92	
114405	1	
114576	10	
114718	8	
115698	39	
116169	200	
100	Each	

NAS1149C0463R



Purchased No

184.0000 3



3

10/11/1958

Washer

Location	Loc Qty	Loc Code
ST297	184	
112314	8	
115358	176	

NAS1149F0563P



Purchased No

188.0000 4



4

10/11/1958

Washer

Location	Loc Qty	Loc Code
ST275	2	
108471	2	
ST298	186	
114576	186	

Picklist Print

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Friday, November 19, 2010 8:44:48 AM

Work Order ID: 63925



Parent Item: D4272-013



Parent Item Name: Basket Assembly, Lightweight Lid, LH

Start Date: 11/19/2010

Required Date: 11/19/2010

Start Qty: 1.00

Required Qty: 1.00

NAS151SH4L



WASHER

Purchased

No

100

Each

116.0000

2

2

18/11/10 SF

Location	Loc Qty	Loc Code
----------	---------	----------

FG	40	
----	----	--

103691	40	
--------	----	--

ST277	76	
-------	----	--

112492	11	
--------	----	--

114265 X	65	
----------	----	--

MS17984-C413



PIN, QUICK RELEASE

Purchased

No

100

Each

12.0000

2

2

10/11/10 EC

Location	Loc Qty	Loc Code
----------	---------	----------

ST297	4	
-------	---	--

114340	4	
--------	---	--

ST314	3	
-------	---	--

114523	1	
--------	---	--

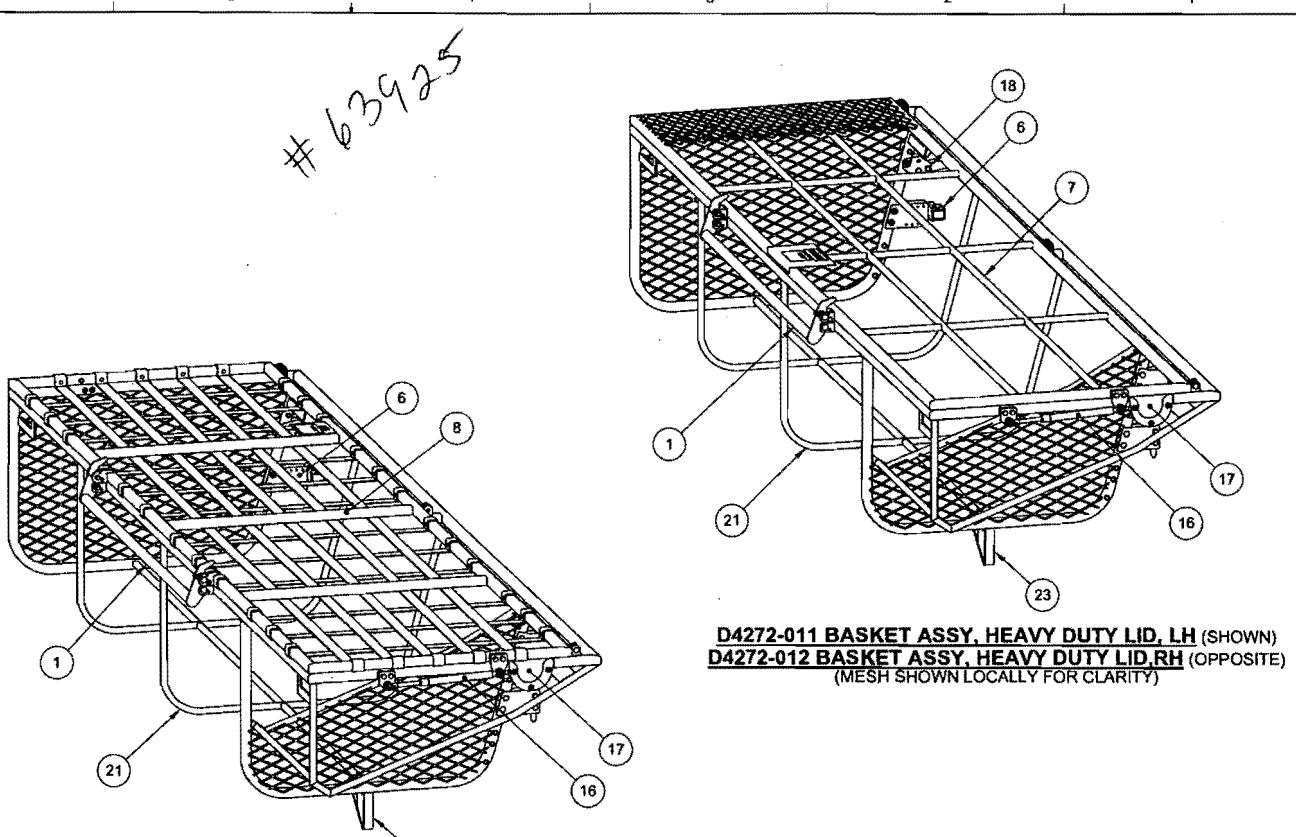
114886	2	
--------	---	--

ST315	5	
-------	---	--

116081	5	
--------	---	--

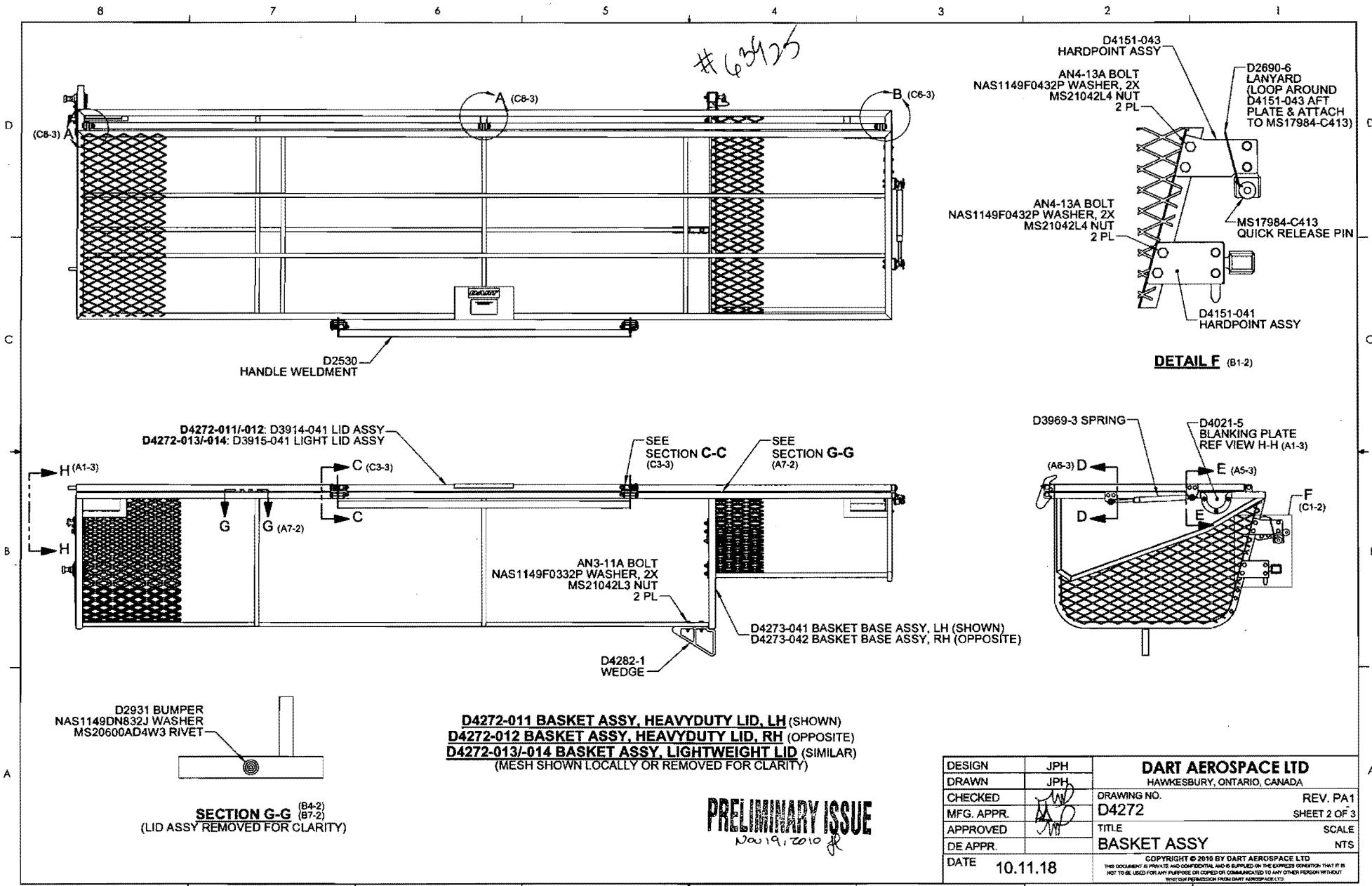
ITEM	QTY -011	QTY -012	QTY -013	QTY -014	PART NUMBER	DESCRIPTION
					D4272-011	BASKET ASSY, HEAVY DUTY LID, LH
					D4272-012	BASKET ASSY, HEAVY DUTY LID, RH
					D4272-013	BASKET ASSY, LIGHTWEIGHT LID, LH
					D4272-014	BASKET ASSY, LIGHTWEIGHT LID, RH
D	1	1	1	1	D2530	HANDLE WELDMENT
	2	2	2	2	D2535	SPRING
	3	2	2	2	D2537	BUSHING
	4	2	2	2	D2690-6	LANYARD
	5	2	2	2	D2931	BUMPER
	6	1	1	1	D3912-041	EYEBOLT RECEIVER ASSY
	7	1	1		D3914-041	BASKET LID ASSY
	8		1	1	D3915-041	LIGHT LID ASSY
	9	6	6	6	D3917-3	WASHER
	10	2	2	2	D3953-3	GAS SPRING STUD, LH
	11	2	2	2	D3953-7	GAS SPRING SPACER
	12	2	2	2	D3953-9	GAS SPRING WASHER
	13	2	2	2	D3953-17	GAS SPRING SPACER
	14	1	1	1	D3953-19	GAS SPRING BRACKET
	15	1	1	1	D3953-21	GAS SPRING BRACKET
	16	1	1	1	D3969-3	GAS SPRING
	17	1	1	1	D4021-5	BLANKING PLATE
	18	1	1	1	D4150-041	ATTACHMENT ARM ASSY
	19	1	1	1	D4151-041	BASKET HARDPOINT ASSY (LOWER)
	20	1	1	1	D4151-043	BASKET HARDPOINT ASSY (UPPER)
	21	1		1	D4273-041	BASKET BASE ASSY, LH
	22		1	1	D4273-042	BASKET BASE ASSY, RH
	23	1	1	1	D4282-1	WEDGE
	24	3	3	3	AN3-10A	BOLT
	25	2	2	2	AN3-11A	BOLT
	26	4	4	4	AN3-14A	BOLT
	27	2	2		AN3-16A	BOLT
	28		2	2	AN3-20A	BOLT
	29	3	3	3	AN4-12	BOLT
	30	6	6	6	AN4-13A	BOLT
	31	1	1	1	AN4C15	BOLT
	32	4	4	2	AN5-17A	BOLT
	33		2	2	AN5-21A	BOLT
	34	3	3	3	AN310-4	NUT, CASTELLATED
	35	3	3	3	AN310C4	NUT, CASTELLATED
	36	2	2	2	MS17984-C413	QUICK RELEASE PIN
	37	2	2	2	MS20600AD4W3	RIVET
	38	11	11	11	MS21042L3	NUT
	39	6	6	6	MS21042L4	NUT
	40	4	4	4	MS21042L5	NUT
	41	4	4	4	MS24665-151	COTTER PIN
	42	2	2	2	MS24665-300	COTTER PIN
	43	2	2	2	NAS1149DN832J	WASHER (ALT: AN960JD8)
	44	18	18	18	NAS1149F0332P	WASHER
	45	2	2	2	NAS1149C0432R	WASHER
	46	18	18	18	NAS1149F0432P	WASHER
	47	3	3	3	NAS1149C0463R	WASHER
	48	4	4	4	NAS1149F0583P	WASHER
	49	2	2	2	NAS1515H4L	WASHER

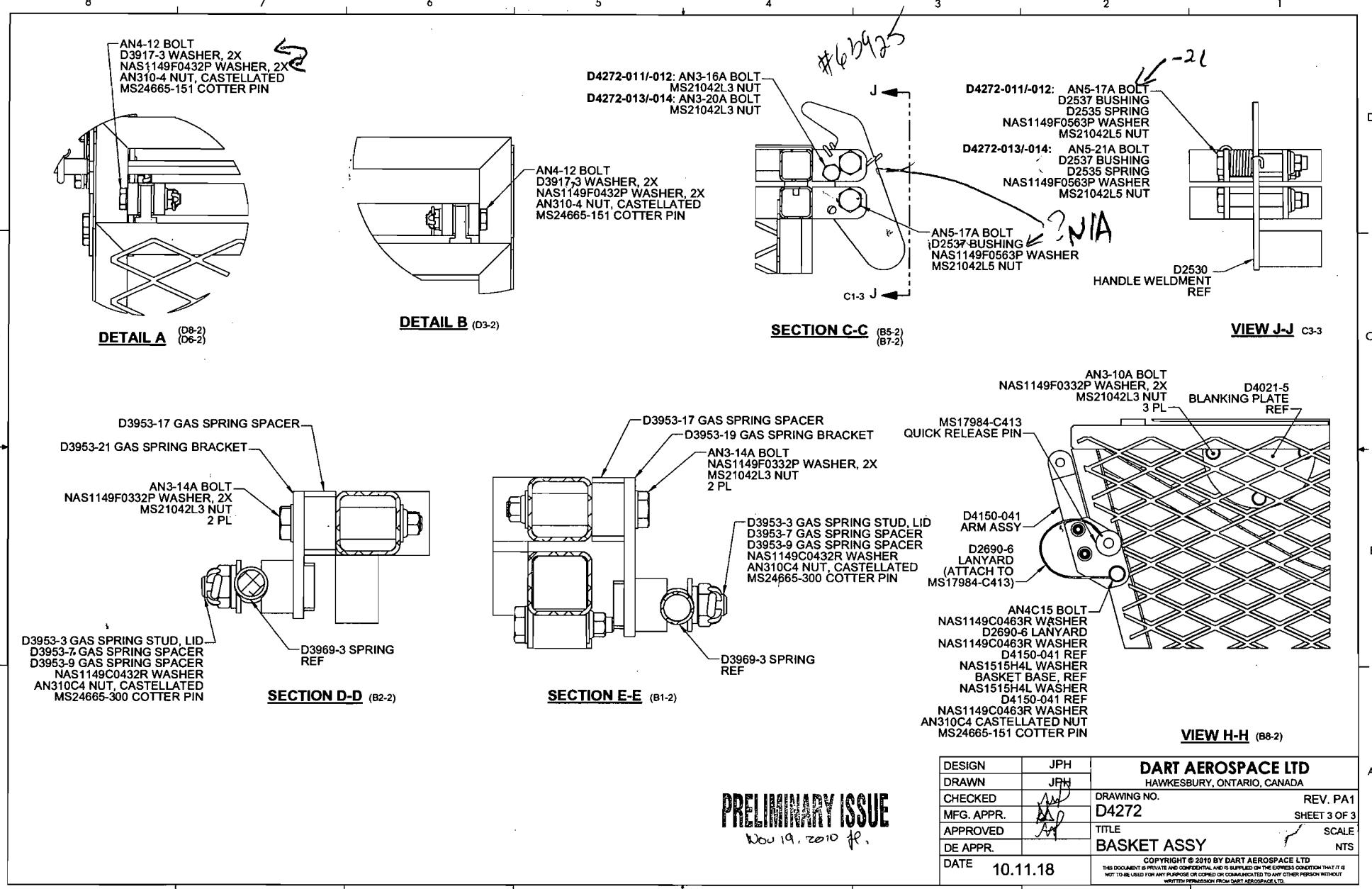
A
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -011/-012: 70 lbs APPROX
-013/-014: 55 lbs APPROX



**D4272-013 BASKET ASSY, LIGHTWEIGHT LID, LH (SHOWN)
D4272-014 BASKET ASSY, LIGHTWEIGHT LID, RH (OPPOSITE)
(MESH SHOWN LOCALLY FOR CLARITY)**

PA1	PRELIMINARY		JPH	10.11.18
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH		DART AEROSPACE LTD	
DRAWN	JPH		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH		DRAWING NO.	REV. PA1
MFG. APPR.	JPH		D4272	SHEET 1 OF 3
APPROVED	JPH		TITLE	SCALE
DE APPR.	JPH		BASKET ASSY	NTS
DATE	10.11.18		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

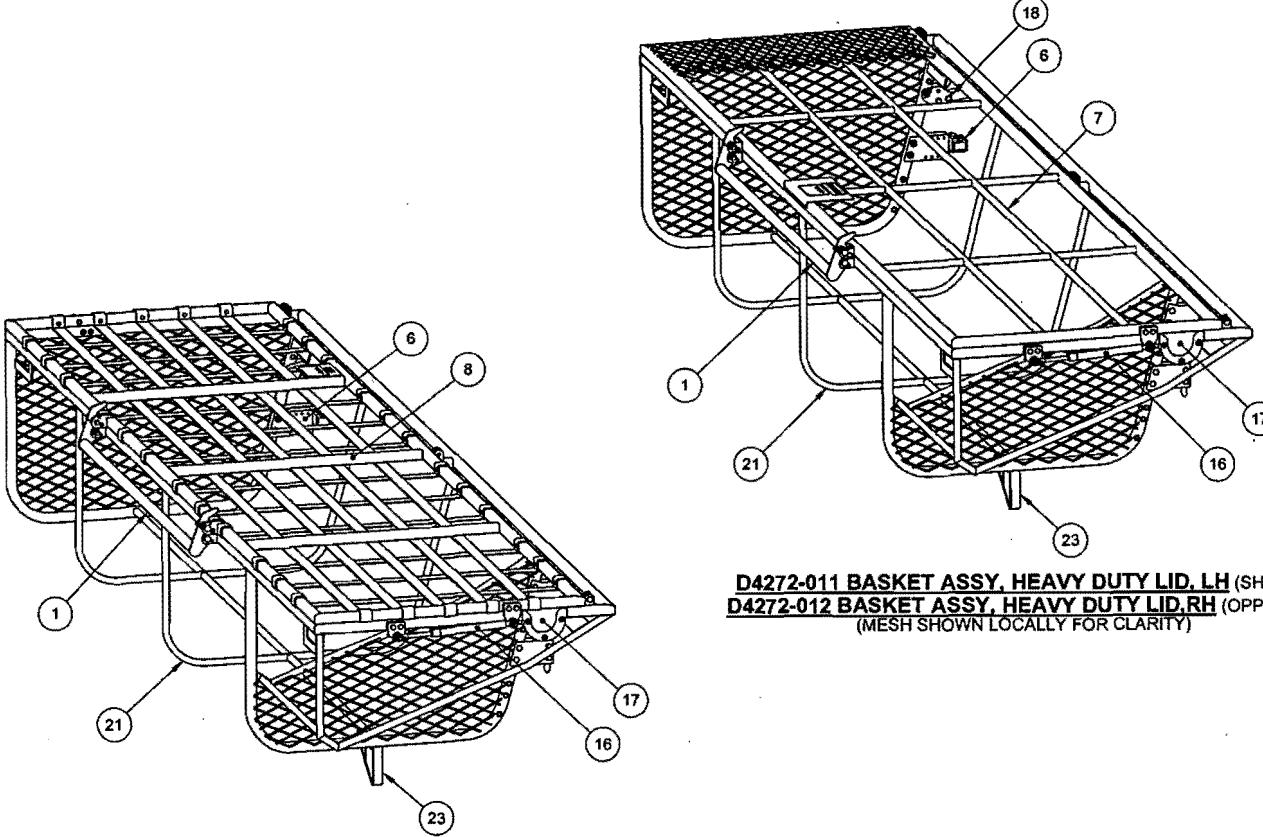




ITEM	QTY -011	QTY -012	QTY -013	QTY -014	PART-NUMBER	DESCRIPTION
					D4272-011	BASKET ASSY, HEAVY DUTY LID, LH
					D4272-012	BASKET ASSY, HEAVY DUTY LID, RH
					D4272-013	BASKET ASSY, LIGHTWEIGHT LID, LH
					D4272-014	BASKET ASSY, LIGHTWEIGHT LID, RH
1	1	1	1	1	D2530	HANDLE WELDMENT
2	2	2	2	2	D2535	SPRING
3	2	2	2	2	D2537	BUSHING
4	2	2	2	2	D2690-6	LANYARD
5	2	2	2	2	D2931	BUMPER
6	1	1	1	1	D3912-041	EYEBOLT RECEIVER ASSY
7	1	1			D3914-041	BASKET LID ASSY
8		1	1	1	D3915-041	LIGHT LID ASSY
9	6	6	6	6	D3917-3	WASHER
10	2	2	2	2	D3953-3	GAS SPRING STUD, LH
11	2	2	2	2	D3953-7	GAS SPRING SPACER
12	2	2	2	2	D3953-9	GAS SPRING WASHER
13	2	2	2	2	D3953-17	GAS SPRING SPACER
14	1	1	1	1	D3953-19	GAS SPRING BRACKET
15	1	1	1	1	D3953-21	GAS SPRING BRACKET
16	1	1	1	1	D3969-3	GAS SPRING
17	1	1	1	1	D4021-5	BLANKING PLATE
18	1	1	1	1	D4150-041	ATTACHMENT ARM ASSY
19	1	1	1	1	D4151-041	BASKET HARDPOINT ASSY (LOWER)
20	1	1	1	1	D4151-043	BASKET HARDPOINT ASSY (UPPER)
21	1				D4273-041	BASKET BASE ASSY, LH
22		1	1	1	D4273-042	BASKET BASE ASSY, RH
23	1	1	1	1	D4282-1	WEDGE
24	3	3	3	3	AN3-10A	BOLT
25	2	2	2	2	AN3-11A	BOLT
26	4	4	4	4	AN3-14A	BOLT
27	2	2			AN3-16A	BOLT
28		2	2		AN3-20A	BOLT
29	3	3	3	3	AN4-12	BOLT
30	6	6	6	6	AN4-13A	BOLT
31	1	1	1	1	AN4C15	BOLT
32	4	4	2	2	ANS-17A	BOLT
33		2	2		ANS-21A	BOLT
34	3	3	3	3	AN310-4	NUT, CASTELLATED
35	3	3	3	3	AN310C4	NUT, CASTELLATED
36	2	2	2	2	MS17984-C413	QUICK RELEASE PIN
37	2	2	2	2	MS20600AD4W3	RIVET
38	11	11	11	11	MS21042L3	NUT
39	6	6	6	6	MS21042L4	NUT
40	4	4	4	4	MS21042L5	NUT
41	4	4	4	4	MS24685-151	COTTER PIN
42	2	2	2	2	MS24685-300	COTTER PIN
43	2	2	2	2	NAS1149DN832J	WASHER (ALT: AN960JD8)
44	18	18	18	18	NAS1149F0332P	WASHER
45	2	2	2	2	NAS1149C0432R	WASHER
46	18	18	18	18	NAS1149F0432P	WASHER
47	3	3	3	3	NAS1149C0463R	WASHER
48	4	4	4	4	NAS1149F0563P	WASHER
49	2	2	2	2	NAS151SH4L	WASHER

NOTES:

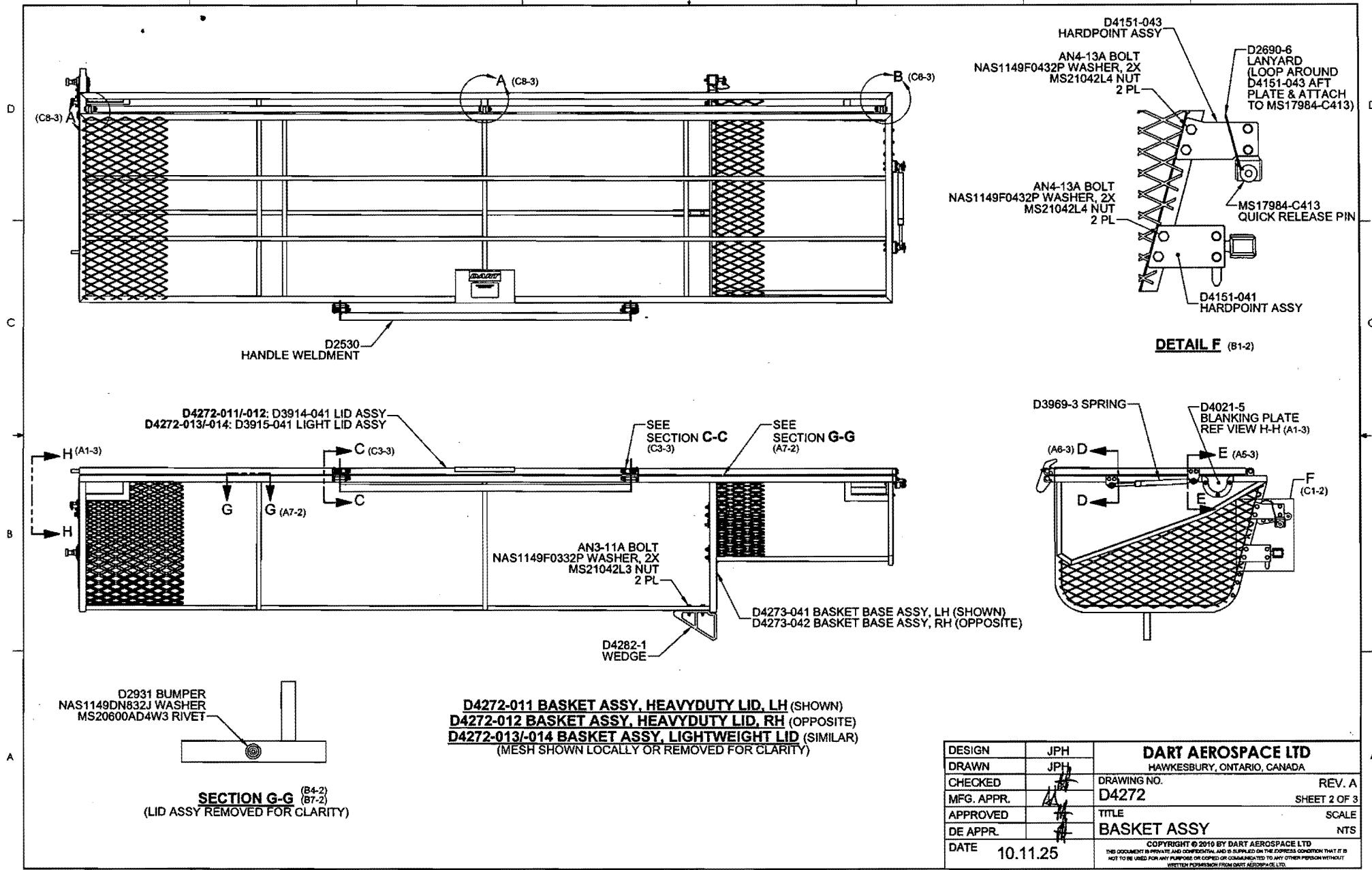
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -011/-012: 70 lbs APPROX
-013/-014: 55 lbs APPROX



D4272-013 BASKET ASSY, LIGHTWEIGHT LID, LH (SHOWN)

D4272-014 BASKET ASSY, LIGHTWEIGHT LID, RH (OPPOSITE)
(MESH SHOWN LOCALLY FOR CLARITY)

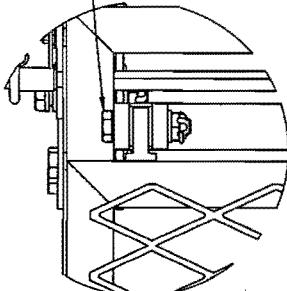
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4272	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSY	NTS
DATE	10.11.25	COPRIGHT © 2010 BY DART AEROSPACE LTD	
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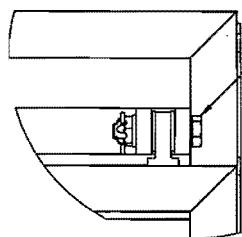
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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	#	REV. A	
APPROVED	#	D4272	
DE APPR.	#	SHEET 2 OF 3	
DATE	10.11.25	TITLE	SCALE
		BASKET ASSY	NTS

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AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



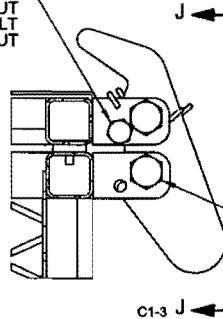
DETAIL A (D8-2)
(D8-2)



DETAIL B (D3-2)

D4272-011/-012: AN3-16A BOLT
MS21042L3 NUT
D4272-013/-014: AN3-20A BOLT
MS21042L3 NUT

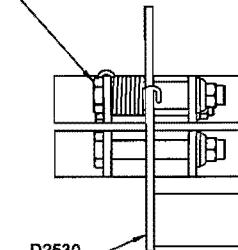
AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



SECTION C-C (B5-2)
(B7-2)

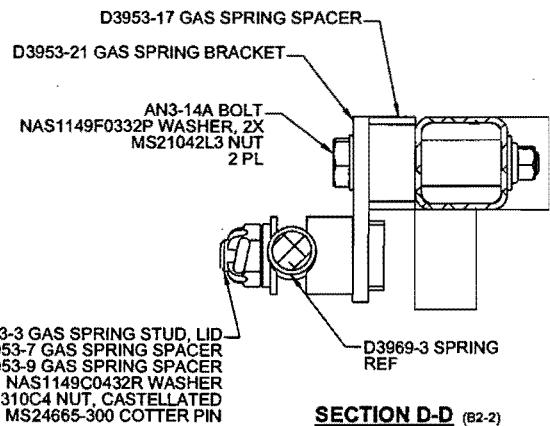
D4272-011/-012: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4272-013/-014: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

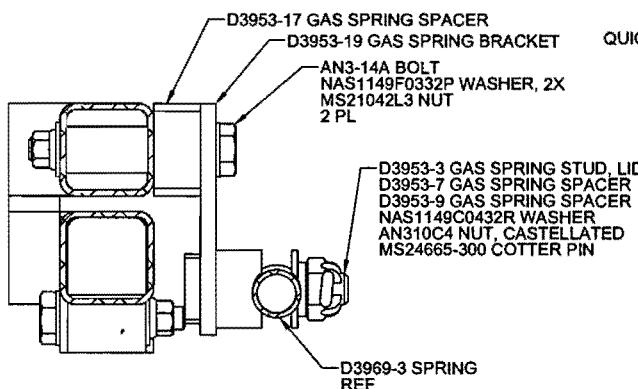


HANDLE WELDMNT
REF D2530

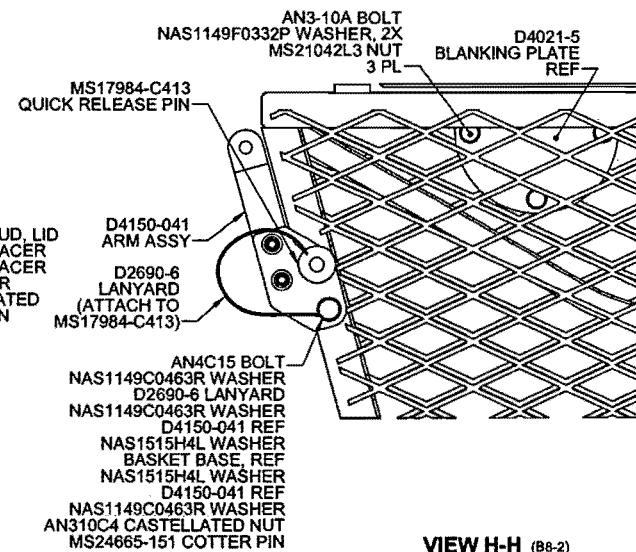
VIEW J-J C3-3



SECTION D-D (B2-2)



SECTION E-E (B1-2)



VIEW H-H (B8-2)

DESIGN	JPH	DART AEROSPACE LTD
DRAWN	JPH	HAWKSLEY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4272 REV. A
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE
DE APPR.		SCALE
DATE	10.11.25	BASKET ASSY NTS

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8 7 6 5 4 3 2 1